

Date: Friday, 07/03/2008 11:03:48 AM  
User: Jean-Luc Menard

## Process Sheet

|                       |  |                  |                                    |
|-----------------------|--|------------------|------------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : 212/205 HIGH AFT X-TUBE ASSEMBLY |
| Job Number            | : 37693  |                  |                                    |
| Estimate Number       | : 10257  |                  |                                    |
| P.O. Number           | :  | Part Number      | : D212664201 <i>TRN</i>            |
| This Issue            | : 07/03/2008 S.O. No. :  | Drawing Number   | : D212-664-241 REV C               |
| Prsht Rev.            | : NC   | Project Number   | : N/A                              |
| First Issue           | : 11   | Drawing Revision | : C                                |
| Previous Run          | : 37058  | Material         | :                                  |
| Written By            | : <i>JLM/08-03-07</i>  | Due Date         | : 14/03/2008 Qty: 1 Um: Each       |
| Checked & Approved By | :  |                  |                                    |
| Comment               | : Est Rev:E 04.02.16 Reformat K/DS<br>Est Rev:F 06-03-29 Remove Comments on Pick List JLM<br>Est Rev:G 07-04-30 As per Rev C JLM |                  |                                    |

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

N/A *JLM*

2.0 D6006129 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube *B-34020*

Check OD = 3.250"; ID = 2.220"

*J.F. 08/03/19 ①*

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

*P.T.O. →*

Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

*am/J.F. 08/03/14 ①*

4.0 QC1 INSPECT ALL DIM TO DIM SHEET

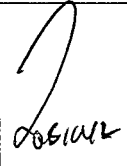


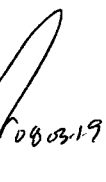


Comment: INSPECT ALL DIM TO DIM SHEET

*am/J.F. 08/03/14 ①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D212-664-201 TRN PAR #: N/A Fault Category: Prod/Machines PAB NCR: Yes No DQA: D Date: 08/04/14  
 QA: N/C Closed: D Date: 08/04/14

| NCR: <u>37693</u> |      | WORK ORDER NON-CONFORMANCE (NCR)   |  |  |                  |   |  |   |
|-------------------|------|--|--|--|------------------|---|--|---|
| DATE              | STEP | Description of NC<br>Section A   | Corrective Action Section B  |  |                  | Verification<br>Section C   | Approval<br>Chief Eng  | Approval<br>QC Inspector  |
|                   |      |  | Initial<br>Chief Eng   | Action Description<br>Chief Eng  | Sign &<br>Date   |   |  |   |
| 08/03/19          | 3.0  | The length of the tube is about .040" over tolerance. Material expands and flares at both ends after machining.<br>* on the total length |  | Acceptable<br>ensure tube is placed/<br>positioned correctly & origins<br>are correct. | J.F.<br>08/03/19 | <br>0803-20 | <br>081042 | <br>0803-19 |
|                   |      |  |  |  |                  |   |  |   |
|                   |      |  |  |  |                  |   |  |   |

NOTE: Date & initial all entries

Date: Friday, 07/03/2008 11:03:48 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37693

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

a.m / J.F. 08/03/19 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

a.m / J.F. 08/03/19 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5 08/08/20 ②

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

a.m 08-03-19 ①

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

a.m 08-03-19 ①

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 8-3-31

1-Polish entire outside surface of crosstube

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AWM 8-3-31 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

AWM 8-3-31

126 ID + STK

DP

8-4-2.

Date: Friday, 07/03/2008 11:03:48 AM  
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## Process Sheet

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37693

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP 8-4-2*

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

14.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

15.0

LANDING GEAR

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

*studs 25 turned only*

*u*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: \_\_\_\_\_

LPI as per ASTM 1417 Level 2

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37693

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0242 sf(s)/Unit Total : 0.0242 sf(s)

Rubber Cushion (per sq ft)

.63" x 5.300

Batch:

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37693

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |           |                          |
|------|-----------|--------------------------|
| 26.0 | MS2192028 | Clamp(per MIL-DTL-8783C) |
|------|-----------|--------------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

|      |                |                         |
|------|----------------|-------------------------|
| 27.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|------|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch:

Expiry Date:

2-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

|      |     |                              |
|------|-----|------------------------------|
| 28.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

|      |             |                       |
|------|-------------|-----------------------|
| 29.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

|      |        |         |
|------|--------|---------|
| 30.0 | D34281 | Placard |
|------|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch:

|      |        |      |
|------|--------|------|
| 31.0 | AN640A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37693

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |        |      |
|------|--------|------|
| 32.0 | AN641A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

|      |            |        |
|------|------------|--------|
| 33.0 | AN960JD616 | Washer |
|------|------------|--------|



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Washer  
Batch: \_\_\_\_\_

|      |           |     |
|------|-----------|-----|
| 34.0 | MS21042L6 | Nut |
|------|-----------|-----|



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut  
Batch: \_\_\_\_\_

|      |     |                                    |
|------|-----|------------------------------------|
| 35.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

|      |             |                       |
|------|-------------|-----------------------|
| 36.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: HAND FINISHING RESOURCE #1  
Identify and pack for shipping as per PPP D212-664-201

|      |      |                              |
|------|------|------------------------------|
| 37.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-02

W



|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>PH</i>           | DRAWN BY<br><i>PH</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                 |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D212-664-241  | REV. C<br>SHEET 1 OF 3 |
| DATE<br>07.03.08              |                                | TITLE<br>CROSSTUBE ASS'Y (205/212 HI AFT) NTS                            |                        |
| A                             | 00.12.12                       | NEW ISSUE  |                        |
| B                             | 05.02.04                       | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES                        |                        |
| C                             | 07.03.08                       | REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS |                        |

**RELEASED**  
07.04.24 *[Signature]*  
PER E.C.N. 225

| Qty | Part Number    | Description   |
|-----|----------------|---|
| X   | D212-664-241   | CROSSTUBE ASSEMBLY (205/212 HIGH AFT)   |
| 1   | D6006-129      | CROSSTUBE   |
| 2   | D2940-1        | SUPPORT   |
| 4   | D3595-063-530  | RUBBER CUSHION  |
| 4   | MS21920-28     | CLAMP (OR MS21920-30)   |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

#### GENERAL NOTES:

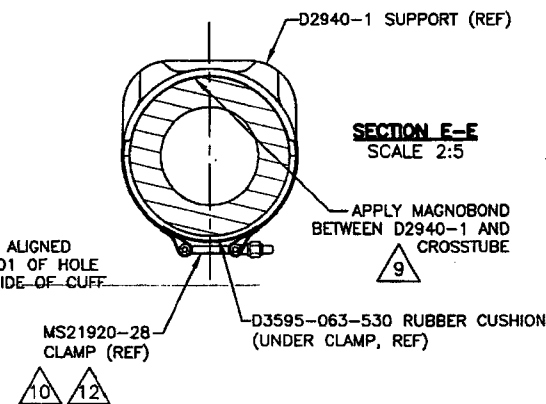
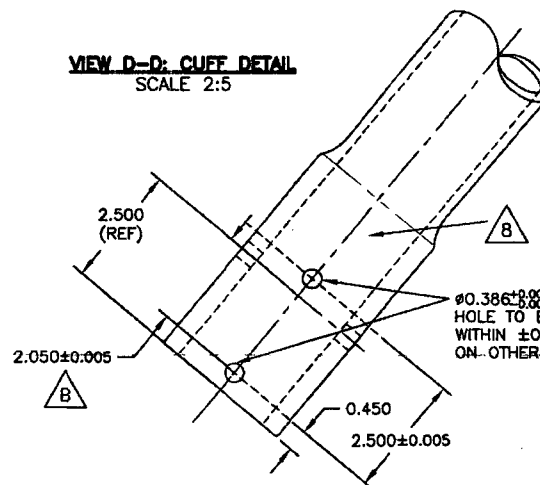
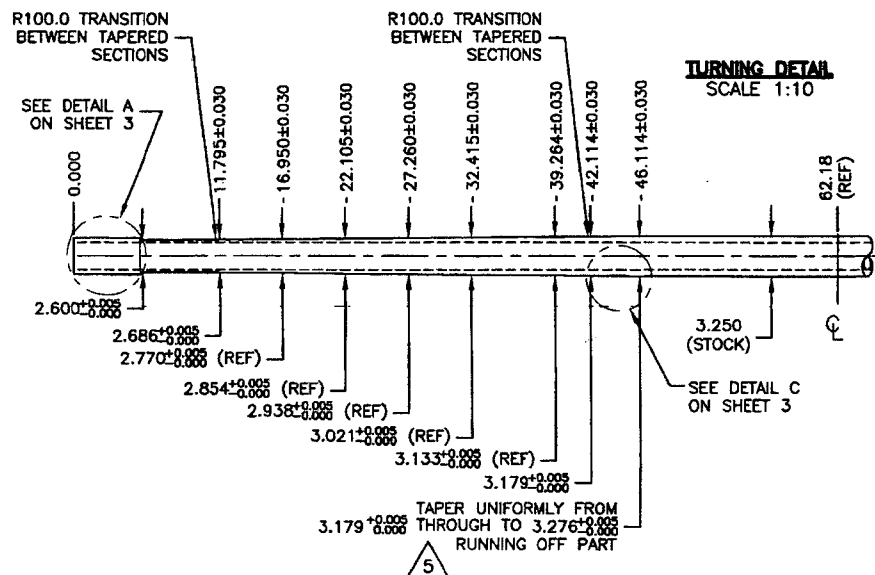
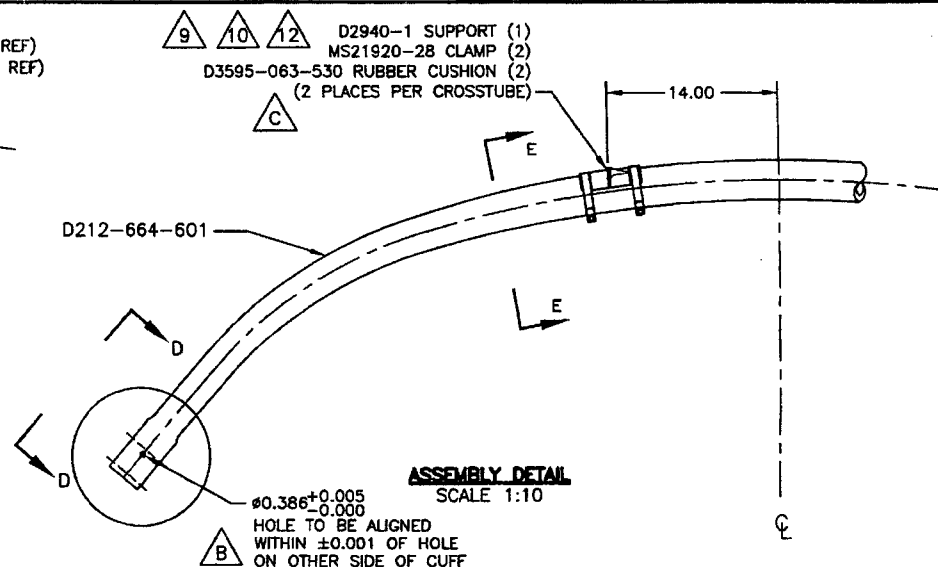
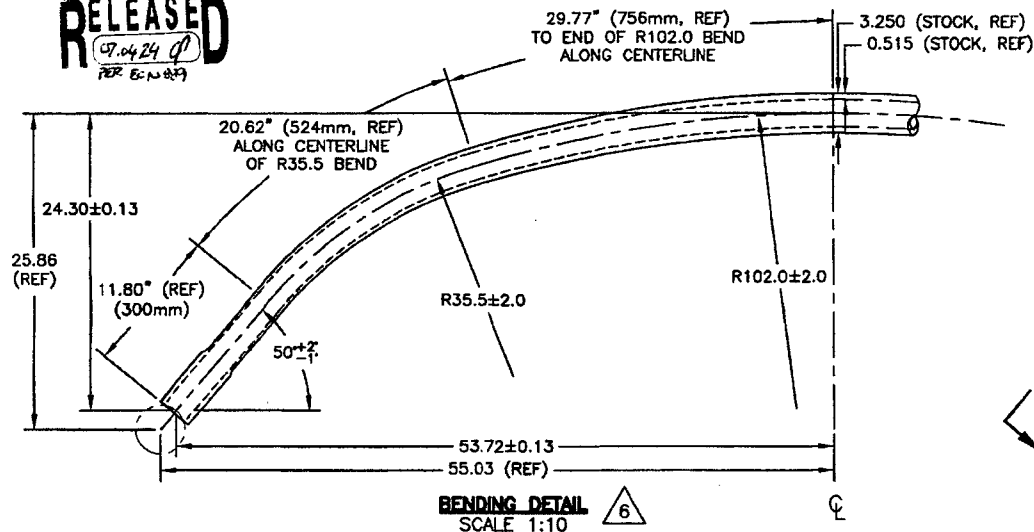
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT  
**NOTE:** MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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**RELEASED**  
 47.0424  
 PER E-12-849

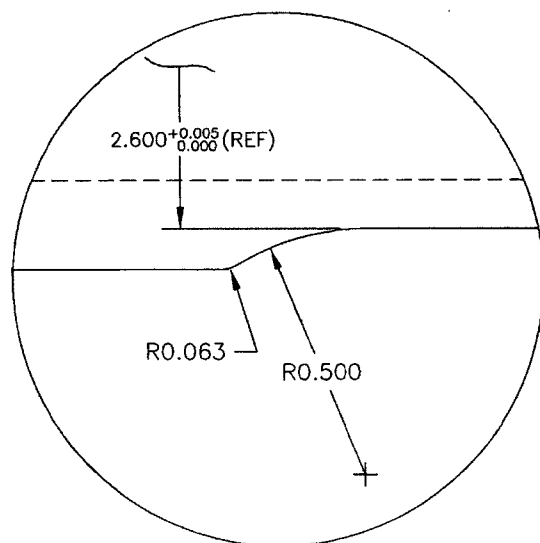
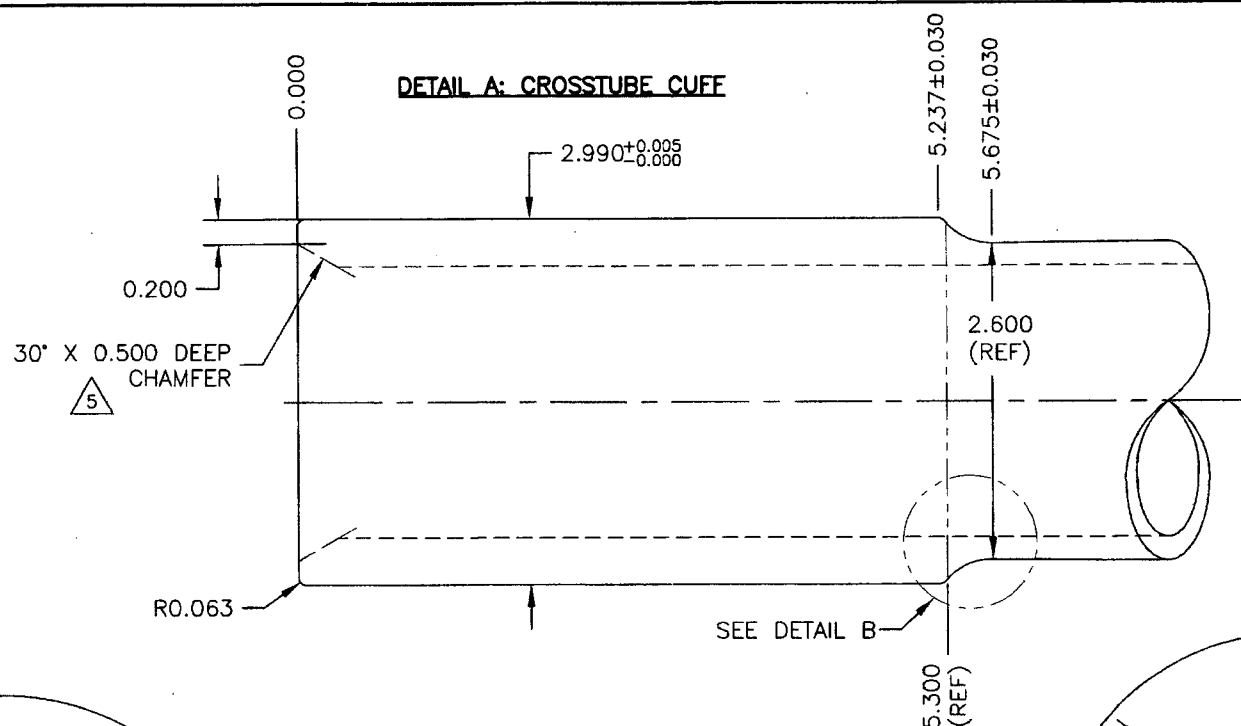


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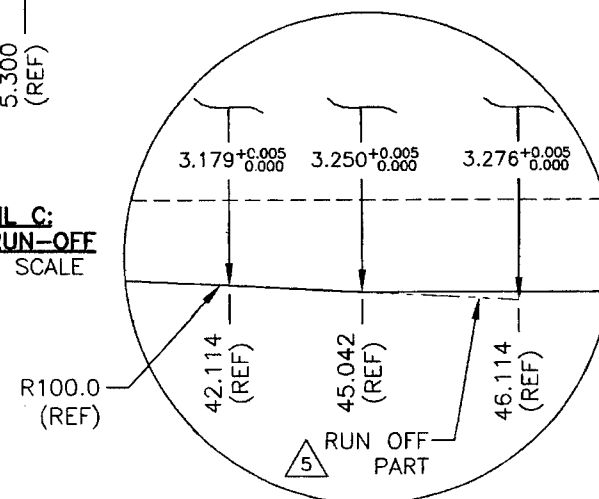
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|         |          |          |                                  |             |  |
|---------|----------|----------|----------------------------------|-------------|--|
| DESIGN  | PH       | DRAWN BY | PH                               | <b>DART</b> | DART AEROSPACE LTD.<br>WILKESBURY, ONTARIO, CANADA |
| CHECKED | J        | APPROVED | A                                | DRAWING NO. | D212-664-241                                       |
| DATE    | 07.03.08 | TITLE    | CROSSTUBE ASS'Y (205/212 HI AFT) | REV. C      | SHEET 2 OF 3                                       |
|         |          |          |                                  | SCALE       | 1:10   |

**RELEASED**  
 07.04.24  
 PER ECN 069



**DETAIL C: TAPER RUN-OFF**  
 NOT TO SCALE



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DESIGN

PH

DRAWN BY

PH

CHECKED

APPROVED

DATE

07.03.08

**DART**

DART AEROSPACE LTD.  
 HARRISBURG, ONTARIO, CANADA

DRAWING NO.

D212-664-241

TITLE

CROSSTUBE ASS'Y (205/212 HI AFT)

REV. C

SHEET 3 OF 3

SCALE

1:1

|   |  |                                  |
|---|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                 |  | <b>Work Order:</b> 37693         |
| <b>Description:</b> Crosstube Assembly (205/212 High Aft) |  | <b>Part Number:</b> D212-664-241 |
| <b>Inspection Dwg:</b> D212-664-241 Rev: C                |  | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |        | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|--------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A                                | 0.200  | +/-0.010      | 0.200"              | ✓      |        |                         |          |
|                                       | R0.063 | +/-0.010      | R0.063"             | ✓      |        |                         |          |
|                                       | 2.990  | +0.005/-0.000 | 2.994"              | ✓      |        |                         |          |
|                                       | 5.237  | +/-0.030      | 5.258"              | ✓      |        |                         |          |
|                                       | 2.600  | +0.005/-0.000 | 2.605"              | ✓      |        |                         |          |
|                                       | 2.686  | +0.005/-0.000 | 2.691"              | ✓      |        |                         |          |
|                                       | 2.770  | +0.005/-0.000 | 2.775"              | ✓      |        |                         |          |
|                                       | 2.854  | +0.005/-0.000 | 2.858"              | ✓      |        |                         |          |
|                                       | 2.938  | +0.005/-0.000 | 2.941"              | ✓      |        |                         |          |
|                                       | 3.021  | +0.005/-0.000 | 3.026"              | ✓      |        |                         |          |
|                                       | 3.133  | +0.005/-0.000 | 3.138"              | ✓      |        |                         |          |
|                                       | 3.179  | +0.005/-0.000 | 3.182"              | ✓      |        |                         |          |
|                                       |        |               |                     |        |        |                         |          |
|                                       |        |               |                     |        |        |                         |          |
| SIDE B                                | 0.200  | +/-0.010      | 0.200"              | ✓      |        |                         |          |
|                                       | R0.063 | +/-0.010      | R0.063"             | ✓      |        |                         |          |
|                                       | 2.990  | +0.005/-0.000 | 2.994"              | ✓      |        |                         |          |
|                                       | 5.237  | +/-0.030      | 5.248"              | ✓      |        |                         |          |
|                                       | 2.600  | +0.005/-0.000 | 2.605"              | ✓      |        |                         |          |
|                                       | 2.686  | +0.005/-0.000 | 2.691"              | ✓      |        |                         |          |
|                                       | 2.770  | +0.005/-0.000 | 2.775"              | ✓      |        |                         |          |
|                                       | 2.854  | +0.005/-0.000 | 2.858"              | ✓      |        |                         |          |
|                                       | 2.938  | +0.005/-0.000 | 2.941"              | ✓      |        |                         |          |
|                                       | 3.021  | +0.005/-0.000 | 3.026"              | ✓      |        |                         |          |
|                                       | 3.133  | +0.005/-0.000 | 3.138"              | ✓      |        |                         |          |
|                                       | 3.179  | +0.005/-0.000 | 3.184"              | ✓      |        |                         |          |
|                                       | 124.36 | +/-0.020      | 124.380"            | ✓      |        |                         |          |
|                                       |        |               |                     |        |        |                         |          |
|                                       |        |               |                     |        |        |                         |          |

|                               |                       |                            |     |
|-------------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> a.m./J.F. | <b>Audited by:</b> J  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 08.03.18         | <b>Date:</b> 08/03/18 | <b>Date:</b>               | N/A |

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 05.04.27 | New Issue (P/O D412-664-201)     | KJ/JLM     |          |
| B   | 06.03.09 | Tolerance for 5.237 was +/-0.001 | KJ/JLM     |          |
| C   | 07.05.08 | Dwg Rev. updated                 | KJ/JLM     | DA       |